



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4091-1
Job Sheet 168176



Part No: D4091-1

Job Qty: 6 ea

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/10/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

RE-POWDERCOAT GLOSS BLACK.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
145	Rework Start up	6 Ea		11/23/17	0.00	0.00	Start Up Handfinish		
150	Powdercoat	6 pcs		11/24/17	0.00	0.07	Powdercoat1		BR 17-11-21
160	QC	6 pcs		11/24/17	0.00	0.00	QC3		
170	Packaging	6 pcs		11/24/17	0.00	0.00	Packaging3		
180	QC21-SA	6 Ea		11/24/17	0.00	0.00	QC21		DAS 21 9-89 NOV 22 201

M 122878 START: 4:20 O.V.T. 3:20 FINISH: 4:50

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
145-Rework Start up	D4091-1 F161296X3 S011835X3	6	33	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	1.380Inches $\pm$ 0.030	1.410 1.350		
2	Mounting Lug	4.450Inches $\pm$ 0.030	4.480 4.420		
3	Mounting Lug	0.270Inches $\pm$ 0.030	0.300 0.240	Reference	
4	Mounting Lug	1.910Inches $\pm$ 0.030	1.940 1.880		
5	Mounting Lug	0.690Inches $\pm$ 0.030	0.720 0.660		
6	Mounting Lug	0.293Inches $\pm$ 0.010	0.303 0.283		
7	Mounting Lug	0.735Inches $\pm$ 0.010	0.745 0.725	Reference	
8	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
9	Mounting Lug	3.700Inches $\pm$ 0.010	3.710 3.690		
10	Mounting Lug	0.625Inches $\pm$ 0.010	0.635 0.615		
11	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
12	Mounting Lug	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																																																
Job No: 168176 Mtg Date: 11/21/17 Rework Start up D4091-1 PART NO: Revision: Operation: Change No: Mounting Lug S011836 DART AEROSPACE Root Cause <table style="width: 100%; border: none;"> <tr><td>Environment</td><td>☐</td><td>No Re</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Opera</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Suppli</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Trainir</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use fo</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com				Environment	☐	No Re	☐	Design	☐	Opera	☐	Doc/Data	☐	Offset	☐	Equip/Tooling	☐	Suppli	☐	Handling/Pre	☐	Trainir	☐	Material	☐	Use fo	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
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13	Mounting Lug	0.400Inches ± 0.030	0.430 0.370	Radius
14	Mounting Lug	2.310Inches ± 0.010	2.320 2.300	Reference

Plex 11/10/17 12:42 PM dart.poulin.mario

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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